

Work Order ID 69659



Page 1

Monday, May 16, 2011 9:16:27 AM

Item ID:	D206-642-312BL	Accept		Setup	Start	
Revision ID:						
Item Name:	Skidtube RH				Stop	
Start Date:	5/16/2011	Start Qty: 1.00		Cust Item ID:		
Required Date:	6/3/2011	Req'd Qty: 1.00		Customer:		

Reference:

Approvals:	Process Plan:		Date:	11-05-14	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D206-642	N								

100		0.00							
	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy bluefile and create labels per PPP D206-642-312	CHG006							
									ck for CL 11/ae/16
									Sub 11/7
110	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									11/6/17
120	QC4- 100% Inspect kits for completeness	0.00							
QC	Memo	0.00							
Quality Control									TC

B69665

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69659

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Monday, May 16, 2011 9:16:27 AM

Item ID: D206-642-312BL

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube RH

Start Date: 5/16/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/3/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-642-312

Location: _____
PPP Rev: _____

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

MF
11-06-17

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Page 1

Work Order ID: 69659

Parent Item: D206-642-312BL

Parent Item Name: Skidtube RH

Start Date: 5/16/2011

Required Date: 6/3/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: J 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM/EC
 IPP Rev: K 07-12-04 ECN 1080p DD verified by: ec
 IPP Rev: L 08-09-29 as per DSI9421 DD verified by: EC IPP Rev: M
 09-03-02 as per DSI9440 rev.a verified by: EC
 IPP Rev: N 09-03-03 as per DSI9421 rev.b verified by: EC IPP Rev: O
 as per REV.N DD 10.04.19 verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D206-642-341 Replacement Skidtube		Manufactured	No			110	Each	3.0000	1	1			

Location	Loc Qty	Loc Code
FG082	3	
36550	1	
44043	1	
44044	1	

D206-648-013 GHW Modification	CHG002	Manufactured	No			110	Each	10.0000	1	1			
----------------------------------	--------	--------------	----	--	--	-----	------	---------	---	---	--	--	--

Location	Loc Qty	Loc Code
FG120	10	
67596	6	
68347	4	

ATTN: D3414-041 BLUE

D2932-2 Saddle RH Out, 206		Manufactured	No			110	Each	5.0000	1	1			
-------------------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

Location	Loc Qty	Loc Code
ST421	5	
66381	1	
67253	4	

BLUE

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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Work Order ID: 69659

Parent Item: D206-642-312BL

Parent Item Name: Skidtube RH

Start Date: 5/16/2011

Required Date: 6/3/2011

Start Qty: 1.00

Required Qty: 1.00

D2933-2

Manufactured No

110 Each

4.0000



Saddle RH In, 206

Location

Loc Qty

Loc Code

ST421

4

67254

4

BLUE

D2938-2

Manufactured No

110 Each

4.0000



Saddle RH Out, 206

Location

Loc Qty

Loc Code

ST421

4

67255

4

BLUE

D2939-2

Manufactured No

110 Each

4.0000



Saddle RH In, 206

Location

Loc Qty

Loc Code

ST421

4

67256

4

BLUE

AN3-41A

Purchased No

110 Each

273.0000



Bolt

Location

Loc Qty

Loc Code

ST354

273

112431

1

115936

72

116191

200

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 69659

Parent Item: D206-642-312BL

Parent Item Name: Skidtube RH

Start Date: 5/16/2011

Required Date: 6/3/2011

Start Qty: 1.00

Required Qty: 1.00

D2652

Manufactured No

110

Each

224.0000

16 16



Bushing



B657741 S

Location

Loc Qty

Loc Code

FG

44

31985

44

ST019

180

67756

180

MS21042L3

Purchased

No

110

Each

2,247.000

8



Nut



\$

Location

Loc Qty

Loc Code

ST300

2247

116391

11

116540

270

116549

766

~~117441~~

800

117601

400

AN960JD10

NAS1149D0363J

Purchased

No

110

Each

0.0000

8



Washer

AN5-10A

Purchased

No

110

Each

180.0000

4



Bolt



M117291 S

1/6/17 S

Location

Loc Qty

Loc Code

ST337

180

117313

180

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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Work Order ID: 69659

Parent Item: D206-642-312BL

Parent Item Name: Skidtube RH

Start Date: 5/16/2011

Required Date: 6/3/2011

Start Qty: 1.00

Required Qty: 1.00

AN5-11A Purchased No 110 Each 92.0000 4 4
Bolt

Location Loc Qty Loc Code

ST337 92
117313 92

AN960JD516 NAS1149D0563J Purchased No 110 Each 0.0000 8 8
Washer

AN4-6A Purchased No 110 Each 1,153.000 12 12
Bolt

Location Loc Qty Loc Code

ST356 953
115936 153
116400 400
116924 400
ST358 200
117514 200

AN960JD416 NAS1149D0463J Purchased No 110 Each 0.0000 24 24
Washer

MS21042L4 Purchased No 110 Each 4,957.000 12 12
Nut

Location Loc Qty Loc Code

ST300 4957
114718 2
116823 1155
117441 3000
117601 800

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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Work Order ID: 69659

Parent Item: D206-642-312BL

Parent Item Name: Skidtube RH



Start Date: 5/16/2011

Required Date: 6/3/2011

Start Qty: 1.00

Required Qty: 1.00

D3407-043

Manufactured No

110 Each

19.0000



Tow Ring



Location

Loc Qty

Loc Code

ST420

2

66386

2

ST464

17

64071

7

68339

10

BLUE

D3456-1

Manufactured No

110 Each

73.0000



Washer



Location

Loc Qty

Loc Code

FG

7

25701

7

ST054

66

66848

6

68748

60

D3457-1

Manufactured No

110 Each

40.0000



Washer



Location

Loc Qty

Loc Code

FG

10

32409

10

ST054

30

67779

30

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Page 5

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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Picklist Print

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Work Order ID: 69659

Parent Item: D206-642-312BL

Parent Item Name: Skidtube RH

Start Date: 5/16/2011

Required Date: 6/3/2011

Start Qty: 1.00

Required Qty: 1.00

MS21043-4

Purchased

No

110

Each

1,304.000

1

1



Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST300

600

117423

600

ST301

664

116188

-12

116549

176

117601

500

AN4C5A

Purchased

No

110

Each

530.0000

1

1



BOLT

Location

Loc Qty

Loc Code

FP-B

115

112243

115

ST345

415

112243

415

AN960C416

NAS1149C0463
R

Purchased

No

110

Each

0.0000

1

1



washer

1117735 11/6/12

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Page 6

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID: 69659

Parent Item: D206-642-312BL

Parent Item Name: Skidtube RH

Start Date: 5/16/2011

Required Date: 6/3/2011

Start Qty: 1.00

Required Qty: 1.00

D3413-1

Manufactured No

110 Each

34.0000

1

1



Ring

Location

Loc Qty

Loc Code

ST420

19

62961

8

66387

11

ST473

15

65294

1

66945

14

BLUE

D2712

Manufactured No

110 Each

451.0000

10

10



Set Screw

Location

Loc Qty

Loc Code

FG

50

29962

50

ST012

252

66955

252

ST021

149

65115

149

D2934

Manufactured No

110 Each

38.0000

2

2



Saddle Spacer

Location

Loc Qty

Loc Code

FG

6

31929

6

ST027

32

67585

32

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, May 16, 2011 9:16:36 AM

Page 8

Work Order ID: 69659

Parent Item: D206-642-312BL

Parent Item Name: Skidtube RH



Start Date: 5/16/2011

Required Date: 6/3/2011

Start Qty: 1.00

Required Qty: 1.00

D2935

Manufactured No

110

Each

56.0000

2

2



Saddle Spacer



11/6/17

Location

Loc Qty

Loc Code

ST027

56

66564

56

2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

4.5 206 L/L-1/L-3/L-4/407 LOW & HIGH GEAR SKIDTUBES

Item	Qty -311	Qty -312	Qty -341	Qty -347	Qty -013	Part Number	Description
	X					D206-642-311	SKIDTUBE INSTALLATION, LH
		X				D206-642-312	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-341	SKIDTUBE
				X		D206-642-347	WEARSHOE KIT (REPLACES -343)
	1	1			X	D206-648-013	GROUND HANDLING KIT
1			1			D2650-5	SKIDTUBE ASSEMBLY
2A			14			D2651-1	* PLUG ⁽¹⁾
2B			14			D2651-3	* O-RING ⁽¹⁾
3			1			D2646	* AFT CAP ⁽¹⁾
4			2			MS27039-1-08	* SCREW ⁽¹⁾
5			2			AN960JD10L	* WASHER ⁽¹⁾
6	1					D2932-1	SADDLE, FWD OUT, LH
6		1				D2932-2	SADDLE, FWD OUT, RH
7	1					D2933-1	SADDLE, FWD IN, LH
7		1				D2933-2	SADDLE, FWD IN, RH
8	1					D2938-1	SADDLE, AFT OUT, LH
8		1				D2938-2	SADDLE, AFT OUT, RH
9	1					D2939-1	SADDLE, AFT IN, LH
9		1				D2939-2	SADDLE, AFT IN, RH
10	8	8				AN3-41A	BOLT
11	16	16				D2652	BUSHING
12A	8	8				MS21042-3	NUT (OR MS21042L3)
12B	8	8				AN960JD10	WASHER
13	4	4				AN5-10A (OR AN5-11A)	* BOLT ⁽²⁾
14	4	4				AN5-11A (OR AN5-12A)	* BOLT ⁽²⁾
15	8	8				AN960JD516	WASHER
16	12	12				AN4-6A	BOLT
17	24	24				AN960JD416	WASHER
18	12	12				MS21042-4	NUT (OR MS21042L4)
20A			6	6		D3537-1	WEARPAD (REPLACES D2648-3)
21A			1	1		D3537-3	WEARPAD (REPLACES D3429-1)
22A			1	1		D3535-11	WEARSHOE (REPLACES D2656-11)
22B			1	1		D3536-11	GASKET
23A			1	1		D3535-23	WEARSHOE (REPLACES D2656-23)
23B			1	1		D3536-23	GASKET
24A			1	1		D3535-35	WEARSHOE (REPLACES D2656-35)
24B			1	1		D3536-35	GASKET
26A			54	54		MS27039C1-08	SCREW
26B			54	54		AN960C10L	WASHER
26C			54			ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1				D3407-043	TOW RING ASSEMBLY (REPLACES D2968-043)
31	1	1				D3456-1	WASHER
32	1	1				D3457-1	WASHER
33	1	1				MS21043-4	NUT
34	1	1				AN4C5A	BOLT
35	1	1				AN960C416	WASHER
36	1	1				D3413-1	RING (REPLACES D2655)
37	10	10				D2712	SET SCREW
38	2	2				D2934	SADDLE SPACER
39	2	2				D2935	SADDLE SPACER
40					2	D3414-041	GHW LUG (REPLACES D2659)
41					4	AN3C37A	BOLT
42					8	D2652	BUSHING
43					4	MS21043-3	NUT
44					4	AN960C10	WASHER

NOTES: (1) DENOTES THAT PART IS INCLUDED WITH D2650-5 ASSEMBLY ABOVE

(2) CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

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Revision: N

Date: 09.09.09